

Date: Friday, 01/08/2008 3:31:12 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FRONT LEG FITTING ASS'Y	
<b>Job Number</b> :	40947	<b>Part Number</b> :	D3762041	
<b>Estimate Number</b> :	13342	<b>Drawing Number</b> :	D3762 REVA	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	01/08/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	A	
<b>First Issue</b> :	/ /	<b>Type</b> :	LARGE FAB ASSY	
<b>Previous Run</b> :	40946	<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	21/08/2008	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>MD 08.8.05</u>			
<b>Comment</b> :	Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified:EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37621	Fitting
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Fitting

batch: B41007 ✓SP 08.08.19

(16x)

3.0	D37623	Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube

batch: B41008 ✓SP 08.08.19

(8x)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place

2- take pins out before welding

3-weld as per dwg D3762 per QSI004

Alum. rod Batch: H 108037

SP 08.08.19

(8x)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 3:31:12 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT LEG FITTING ASS'Y

Job Number: 40947

Part Number: D3762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-20 (8)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (28)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 08/08/20 (x8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/08/20 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

mf 08-08-21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mf 08-08-21

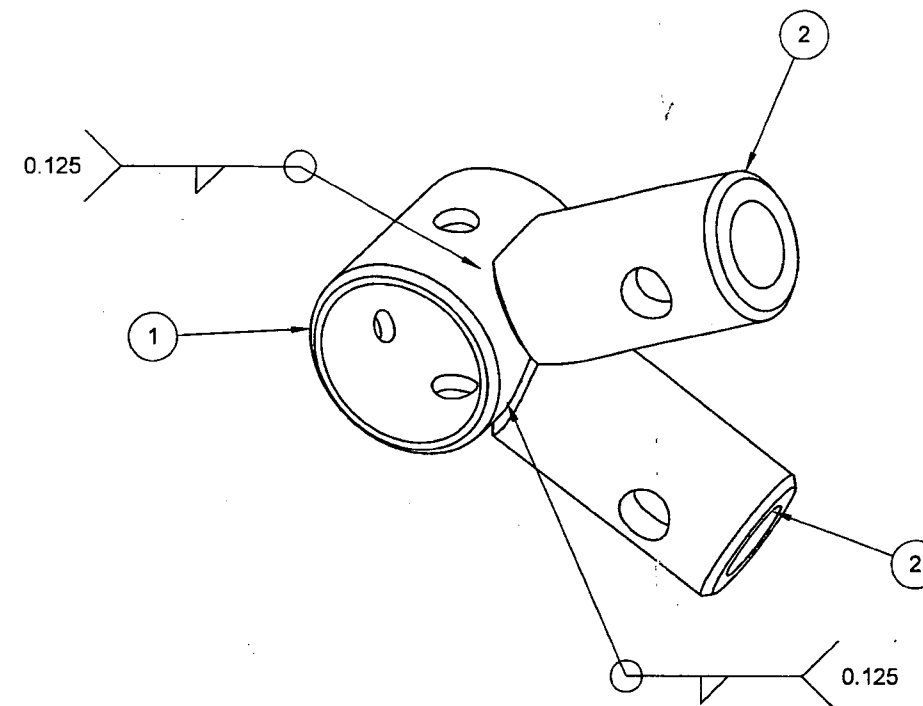
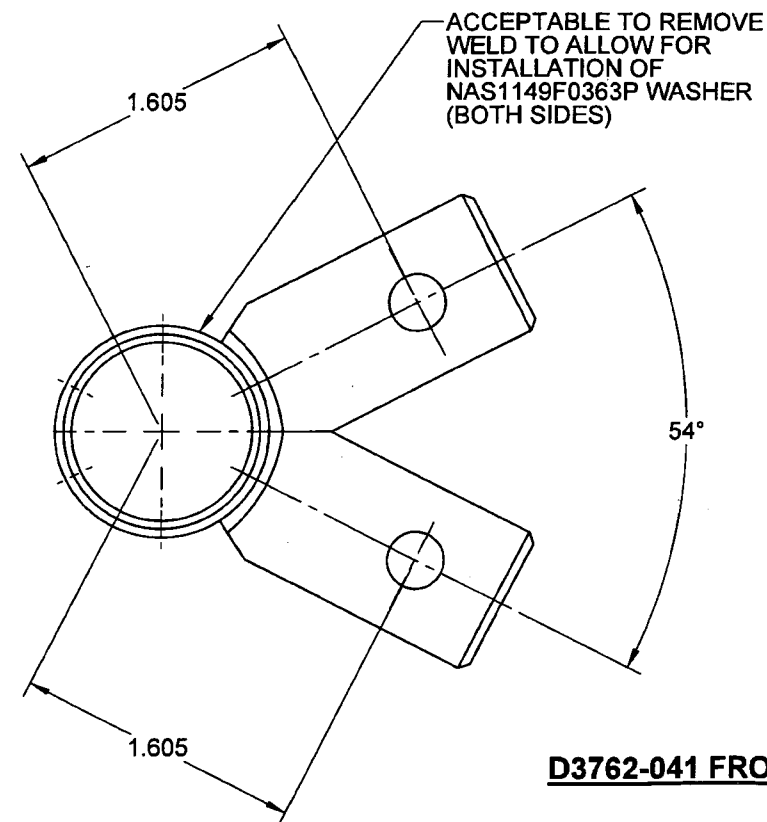
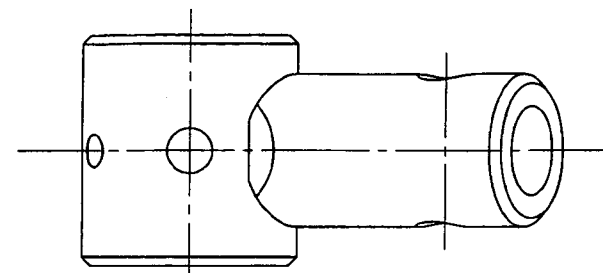
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

# **D3762-041 FRONT LEG FITTING ASSY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

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NO. 140947

A	NEW ISSUE	HS	08.06.04
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	HS	D3762	SHEET 1 OF 3
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8

7

6

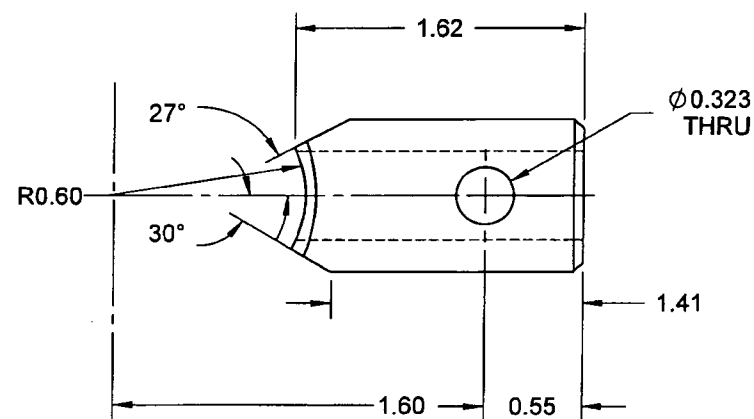
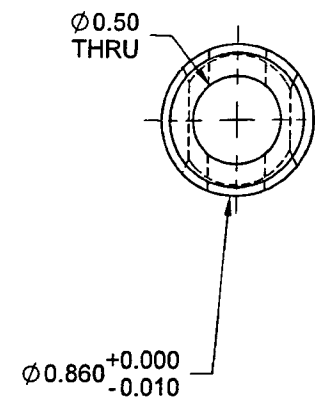
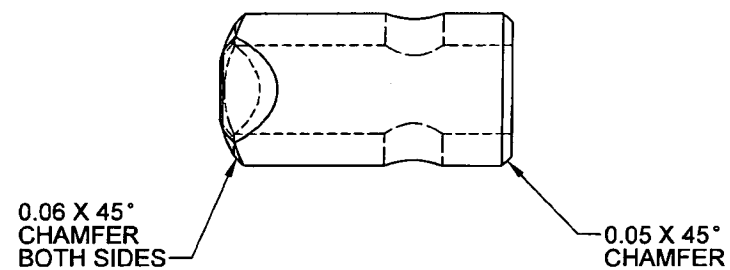
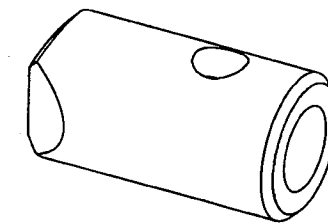
5

4

3

2

1

**D3762-1 FITTING****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

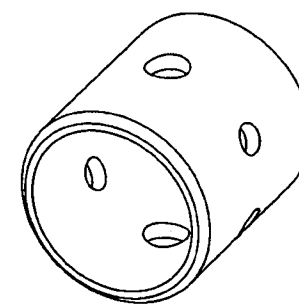
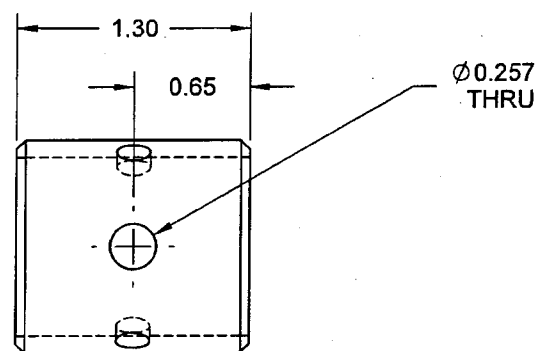
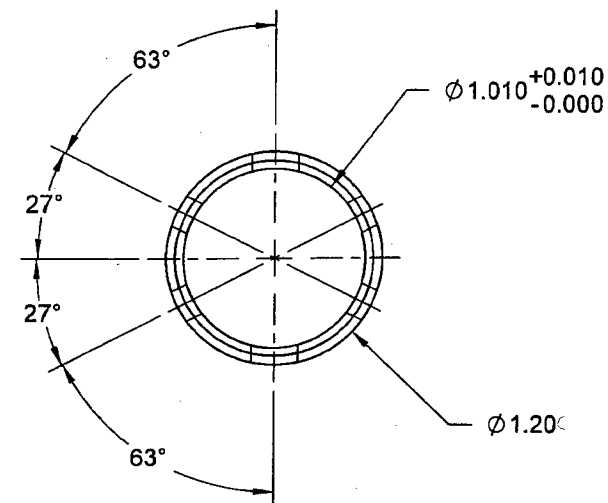
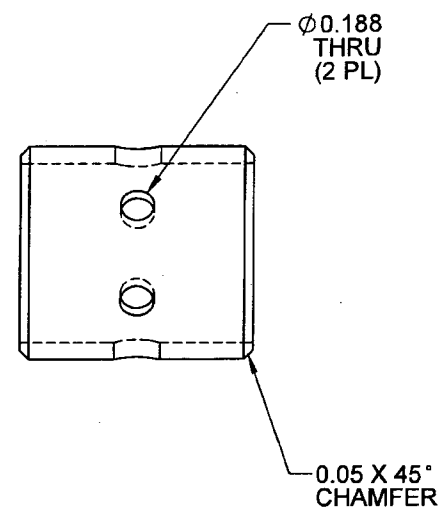
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# **D3762-3 TUBE**

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## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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